



Dart Aerospace Ltd.
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D4171-1**Job Sheet 193534****Part No:** D4171-1**Job Qty:** 30 pcs**Part Name:** Bushing**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/16/19**Job Tracking No:****Due Date:** 4/30/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV A IPP REV:A NEW ISSUE 10-09-22 JLM VERIFIED BY:DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time
100	Doosan - 1	30 pcs	4/30/19	4/30/19	0.00	5.99	Doosan - 1	
140	QC 8	30 pcs	4/30/19	4/30/19	0.00	0.00	QC 8 - 12	
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
200	Packaging 3-1 - Stock - B4B	30 pcs	4/30/19	4/30/19	0.00	0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
							Packaging 3 - 6 - B4B	

Sign off

5

9-89

4/19/05/13

**Container No:** S180790**Part:** D4171-1**Job No:** 193534**Serial No/Batch:** S180790**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 05/13/19

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				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC 51083
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210	QC 21 - SA	30 pcs	4/30/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - (Doosan Lathe) 1-Turn as per Dwg & Folio FA963 Descriptions: 140 - (QC8- Inspect parts - second check) 200 - (Identify as per dwg & Stock Location: _____) 210 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M303R1.000	303 Round Bar 1.00	2.4000 ft (ea)	100-Doosan - 1	5156621	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Doosan - 1	M303R1.000	2	42	0	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.750Inches ± 0.010	0.760 0.740		.750
2	Bushing	0.540Inches ± 0.010	0.550 0.530		.540
3	Bushing	0.210Inches ± 0.010	0.220 0.200		.210
4	Bushing	0.150Inches ± 0.010	0.160 0.140		.151
5	Bushing	0.305Inches $+ 0.000$ $- 0.002$	0.305 0.303	Diameter	.304
6	Bushing	0.010Inches ± 0.010	0.020 0.000	Radius	R.015
7	Bushing	0.060Inches ± 0.010	0.070 0.050		.059
8	Bushing	0.395Inches $+ 0.015$ $- 0.005$	0.410 0.390		.400
9	Bushing	0.563Inches $+ 0.002$ $- 0.015$	0.565 0.548		.5575
10	Bushing	0.880Inches ± 0.030	0.910 0.850	Diameter	.88
11	Bushing	0.191Inches $+ 0.005$ $- 0.001$	0.196 0.190	Diameter	.1935
12	Bushing	0.063Inches ± 0.010	0.073 0.053	Radius	R.0625
13	Bushing	0.060Inches ± 0.010	0.070 0.050	Radius	R.062
14	Bushing	45.000Degrees ± 0.500	45.500 44.500	Angle	45°
15	Bushing	0.023Inches $+ 0.030$ $- 0.010$	0.053 0.013		.043
16	Bushing	0.030Inches ± 0.010	0.040 0.020		.03
17	Bushing	20.000Degrees ± 0.500	20.500 19.500	Angle	20°

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					